



Dart Aerospace Ltd.
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D5661-046
Job Sheet 201822



Part No: D5661-046

Job Qty: 4 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/11/19

Job Tracking No:

Due Date: 11/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5661 Rev A / DSK182 Rev A IPP Rev. A 19.09.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	4 pcs		11/1/19	0.17	1.00	Waterjet - Flow		SRB 11/13/19
120	QC 2	4 pcs		11/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S231309

Part: D5661-046

Job No: 201822

Serial No/Batch: S231309

Revision: A/A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/13/19

PRIORITY

130 QC 8	4 pcs	11/1/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	SRB 11/13/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	NOV 13 2019 DAS 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Small Fab - Brake NC - B4B	4 pcs	11/1/19	0.25 0.67	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	NOV 13 2019
150 QC 5	4 pcs	11/1/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
155 Automated Welding - B4B	4 pcs	11/1/19	0.25 0.67	QC 5 - 61	
				QC 5 - 81	
160 Large Fab - Welded Assy-2-	4	11/1/19	0.00 2.00	Automated Welding - 1 - B4B	
				Large Fab - 1 - B4B	

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B4B	pcs				Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	MR Nov 14/19
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
170 QC 9	4 pcs	11/1/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	
					QC 9 - 9	CR
180 QC 5	4 pcs	11/1/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	CR
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Spray Paint - 2 - B4B	4 pcs	11/1/19	0.00 0.33		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	NOV 19-11-19
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200 QC 5	4 pcs	11/1/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	

				QC 5 - 81	
210 Packaging 3-1 - Stock - B4B	4 pcs	11/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	✓ WP002
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	✓
220 QC 21 - SA	4 ✓ pcs	11/1/19	0.00 0.00	QC 21 - SA - 21	✓ WP002
				QC 21 - SA - 70	21 NOV 15 2019
				QC 21 - SA - 53	21

Part Op 110 - 1-Cut DSK182-5F as per DWG. DWG. Rev: A PROG. Rev: A 2-Deburr if necessary

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - FORM D5661-5F WEARPLATE AS PER DWG

150 - (QC5- Inspect part completeness to step on W/O)

155 - ***USE DT10493*** APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) BATCH: M159025

160 - ***MINIMUM 7 WELDS DISTRIBUTED ACROSS SHIM AND MINIMUM 1 WELD PER INDICATED COLUMN*** 1- WELD SHIMS AS PER DWG A/R Hardcoat S.S. Batch: M176595 2- TRANSFER DRILL 00.188 DRAIN HOLE FROM WEARPLATE THRU SHIM

170 - (QC9- Inspect visual per QSI004- Fusion Welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - 1- COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9 BATCH: 5227557 2- OPEN UP DRAIN HOLE IF NECESSARY TO 0.188 AFTER APPLYING TEXTURED COATING AS PER DWG 3- INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER AFTER FINISH

200 - (QC5- Inspect part completeness to step on W/O)

210 - (Identify as per dwg & Stock Location: _____)

220 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	8.6400 sf (2.16 ea)	110-Waterjet - Flow - 1	S22 Mob
D4682-13	Saddle Shim	4 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	S224 876
D4682-9	Wearplate Shim	4 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	S227 435
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S18GA	9	123	0
160-Large Fab - Welded Assy-2- B4B	D4682-13	4	0	0
	D4682-9	4	29	0
Part Specifications				
Specifications could not be found.				

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INSPECTION SHEET

DA
4C
9-892019Date:

Approved



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)							
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
				Completed By							
				Lead hand / Supervisor							
				QC / QA Coordinator							